

Work Order ID 53581

November 09, 2009 11:28:58 AM



Page 1

Item ID: D209-669-014

Accept



Setup Start



Revision ID: B

Stop



Item Name: Skidtube RH

Start Date: 11/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/23/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-11-09 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D209-669-014 | Rev B | | | | | | | | |
| DSI 9450 | Rev A | | | | | | | | |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D209-669-014 CHG003

Handwritten: \$ 5 8/11/25 09-11-09

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Handwritten: 09-11-09

Large Handwritten: B53536

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 53581

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Item ID: D209-669-014

Accept



Setup Start



Revision ID: B

Stop



Item Name: Skidtube RH

Start Date: 11/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/23/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | Packaging | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPPD209-669-014 Location: _____ | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

278 09/10/25



09/14/25

09/11/26

09-11-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH

Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D209-669-043RevB

Manufactured

No

110

Each

3.0000

1.0000



Replacement Skidtube

Warehouse

Loc Qty

Loc Code

Location

Premier

Mezz

3

22797

1

39205

1

39206

1

D2917-2RevB

Manufactured

No

110

Each

3.0000

2.0000



Saddle RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

3

52129

3

D2918-2RevB

Manufactured

No

110

Each

3.0000

2.0000



Saddle RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

52133

3

53536 PC914/50

53704

353428 PC911/24(1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH


Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN4-51A  Bolt | | Purchased | No | | | 110 | Each | 322.0000 | 8.0000 | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

| | | |
|--------|-----|--|
| ST | 322 | |
| 111635 | 7 | |
| 112489 | 92 | |
| 112720 | 50 | |
| 112805 | 73 | |
| 113121 | 100 | |

11/10/09

D2570RevB



Bushing

Manufactured No

110 Each 391.0000 24.0000



53449 23X / 11/11/09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

| | | |
|-------|-----|--|
| ST | 389 | |
| 47246 | 4 | |
| 52214 | 385 | |

52214 1X

Main Warehouse

| | | |
|-------|---|--|
| ST36 | 2 | |
| 51519 | 2 | |

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH


Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21042L4  Nut | | Purchased | No | | | 110 | Each | 5,764.000 | 24.0000 | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

| | | |
|--------|------|--|
| ST | 5764 | |
| 110507 | 184 | |
| 111827 | 5571 | |
| 112314 | 9 | |
| 15924 | 0 | |

AN5-36A



Bolt

Purchased

No

110

Each

415.0000

4.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

| | | |
|--------|-----|--|
| ST | 415 | |
| 109545 | 11 | |
| 110467 | 7 | |
| 110731 | 4 | |
| 112243 | 20 | |
| 112314 | 323 | |
| 112385 | 50 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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November 09, 2009 11:28:58 AM

Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH


Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960JD516  Washer | | Purchased | No | | | 110 | Each | 1,440.000 | 8.0000 | | | |

11/14/12

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 1440 | |
| 100564 | 2 | |
| 106167 | 6 | |
| 107534 | 34 | |
| 107959 | 43 | |
| 108246 | 46 | |
| 108672 | 2 | |
| 109059 | 49 | |
| 109752 | 22 | |
| 110363 | 46 | |
| 110523 | 57 | |
| 111279 | 39 | |
| 112082 | 64 | |
| 112314 | 500 | |
| 112794 | 30 | |
| 112828 | 500 | |

11/23/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH


Start Date: 11/10/2009

Required Date: 11/23/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MS21042L5  Nut | | Purchased | No | | | 110 | Each | 1,022.000 | 4.0000 | | | |

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1022

110382

10

111127

4

111636

15

112314

993

AN4-7A



Bolt

Purchased

No

110

Each

229.0000

6.0000

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

229

112794

129

112933

100

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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November 09, 2009 11:28:58 AM

Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH


Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN960JD416  Washer | | Purchased | No | | | 110 | Each | 4,361.000 | 32.0000 | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | |
|--------|------|
| ST | 4361 |
| 108161 | 503 |
| 110523 | 340 |
| 111279 | 101 |
| 111916 | 482 |
| 112314 | 2935 |
| 16941 | 0 |

D2929RevB



Spacer

Manufactured No

110 Each 29.0000 2.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | |
|-------|----|
| ST | 29 |
| 43376 | 1 |
| 52243 | 28 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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November 09, 2009 11:28:58 AM

Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH

Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D2930RevB Spacer | | Manufactured | No | | | 110 | Each | 31.0000 | 2.0000 | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 31

43378 2

52249 29

D3405-041RevB

Manufactured

No

110

Each

32.0000

1.0000

Lug Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 17

51673 17

Main Warehouse

ST474 15

52323 15

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH


Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| AN4C47A  Bolt | | Purchased | No | | | 110 | Each | 124.0000 | 4.0000 | ✓ | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

124

112489

2

112641

100

112816

22

11/12/09

MS21043-4

Nut

Purchased

No

110

Each

1,440.000

5.0000

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

40

104603

40

Main Warehouse

ST

1400

112243

2

112314

598

112492

300

113064

500

11/12/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH



Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--|---------------|----------------|--------|
| D3405-043RevB  Lug Assembly | | Manufactured | No | | | 110 | Each | 31.0000 |  1.0000 | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

31

46589

1

46863

1

51652

17

52324

12

51652

D3407-041RevE

Manufactured

No



Tow Ring

110

Each

13.0000



53688

R 9/11/16 C

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

3

35780

3

Main Warehouse

ST

10

48356

1

50755

2

51926

7

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

November 09, 2009 11:28:58 AM

Work Order ID: 53581

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH



Comments:

Start Date: 11/10/2009

Required Date: 11/23/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|---------------|----------------|--------|
| D3456-1RevA  Washer | | Manufactured | No | | | 110 | Each | 178.0000 | 1:0000  | | | |

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

7

25701

7

Main Warehouse

ST

171

51653

171

D3417-5RevE



Washer

Manufactured

No

110

Each

68.0000

2:0000


Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

68

51649

68

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the replacement Dart parts. The weight and balance of the skidtubes that are being removed from the aircraft is the responsibility of the installer.

| Installation | Weight | LONGITUDINAL | |
|-----------------------|---------|--------------|------------|
| | | Arm | Moment |
| D209-669-011/-012 | 49.6 lb | 170.4 in | 8452 in lb |
| SKIDTUBE INSTALLATION | 22.5 kg | 4.33 m | 97.4 m kg |
| D209-669-013/-014 | 43.8 lb | 176.5 in | 7731 in lb |
| SKIDTUBE INSTALLATION | 19.9 kg | 4.48 m | 89.2 m kg |

5.0 PARTS LIST

| Item | Qty -011 | Qty -012 | Qty -013 | Qty -014 | Qty -041 | Qty -043 | Part Number | Description |
|------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|---------------------------------------|
| | X | | | | | | D209-669-011 | SKIDTUBE INSTALLATION, LH (AH-1W/J) |
| | | X | | | | | D209-669-012 | SKIDTUBE INSTALLATION, RH (AH-1W/J) |
| | | | X | | | | D209-669-013 | SKIDTUBE INSTALLATION, LH (AH-1P/F/S) |
| | | | | X | | | D209-669-014 | SKIDTUBE INSTALLATION, RH (AH-1P/F/S) |
| | 1 | 1 | | | X | | D209-669-041 | REPLACEMENT SKIDTUBE (AH-1W/J) |
| | | | 1 | 1 | | X | D209-669-043 | REPLACEMENT SKIDTUBE (AH-1P/F/S) |
| 1A | | | | | 1 | | D2906-041 | SKIDTUBE ASSEMBLY |
| 1B | | | | | | 1 | D2906-043 | SKIDTUBE ASSEMBLY |
| 2 | 1 | | 2 | | | | D2917-1 | OUTER SADDLE (FWD, LH) |
| 3 | | 1 | | 2 | | | D2917-2 | OUTER SADDLE (FWD, RH) |
| 4 | 1 | | 2 | | | | D2918-1 | INNER SADDLE (FWD, LH) |
| 5 | | 1 | | 2 | | | D2918-2 | INNER SADDLE (FWD, RH) |
| 6 | 1 | | | | | | D2919-1 | OUTER SADDLE (AFT, LH) |
| 7 | | 1 | | | | | D2919-2 | OUTER SADDLE (AFT, RH) |
| 8 | 1 | | | | | | D2920-1 | INNER SADDLE (AFT, LH) |
| 9 | | 1 | | | | | D2920-2 | INNER SADDLE (AFT, RH) |
| 10 | 8 | 8 | 8 | 8 | | | AN4-51A | BOLT |
| 11 | 16 | 16 | 16 | 16 | | | D2570 | BUSHINGS |
| 12 | 8 | 8 | 8 | 8 | | | MS21042L4 | NUT (OR MS21042-4) |
| 13 | 2 | 2 | 4 | 4 | | | AN5-36A | BOLT |
| 14 | 2 | 2 | | | | | AN5-41A | BOLT |
| 15 | 8 | 8 | 8 | 8 | | | AN960JD516 | WASHER |
| 16 | 4 | 4 | 4 | 4 | | | MS21042L5 | NUT (OR MS21042-5) |
| 17 | 16 | 16 | 16 | 16 | | | AN4-7A | BOLT |
| 18 | 32 | 32 | 32 | 32 | | | AN960JD416 | WASHER |
| 19 | 16 | 16 | 16 | 16 | | | MS21042L4 | NUT (OR MS21042-4) |

CONTINUED ON NEXT PAGE

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Revision: B
Date: 07.08.23

5358 /

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

CONTINUED FROM PREVIOUS PAGE

| | | | | | | | | |
|------|----|----|---|---|----|----|---------------|--|
| 20 | 2 | 2 | 2 | 2 | | | D2929 | SPACER |
| 21 | 2 | 2 | 2 | 2 | | | D2930 | SPACER |
| *30A | | | | | 1 | 1 | D3564-9 | WEARSHOE (REPLACES D2577-1) |
| *30B | | | | | 1 | 1 | D3566-1 | GASKET |
| *31A | | | | | 1 | | D3564-15 | WEARSHOE (REPLACES 18" D2577-5) |
| *31B | | | | | 1 | | D3566-15 | GASKET |
| *32A | | | | | 1 | 1 | D3564-11 | WEARSHOE (REPLACES D2577-3) |
| *32B | | | | | 1 | 1 | D3566-1 | GASKET |
| *33A | | | | | 1 | 1 | D3564-5 | WEARSHOE (REPLACES D2577-5) |
| *33B | | | | | 1 | 1 | D3566-5 | GASKET |
| *34 | | | | | 50 | 44 | AN3C4A | BOLT (REPLACES AN3-4A) |
| *35 | | | | | 50 | 44 | AN960C10L | WASHER (REPLACES AN960JD10L) |
| *36 | | | | | 50 | 44 | AKS7-1032-130 | INSERT (OR ALS7-1032-130, OR ALS4-1032-130, OR AKS4-1032-130) |
| *37 | | | | | 12 | 14 | D2594-1 | PLUG |
| *38 | | | | | 12 | 14 | D2594-3 | O-RING |
| *40 | | | | | 2 | 2 | D2855 | AFT CAP |
| *41 | | | | | 4 | 4 | AN3-5A | BOLT |
| *42 | | | | | 4 | 4 | AN960JD10L | WASHER |
| *43 | | | | | 4 | 4 | AKS7-1032-225 | INSERT (OR ALS7-1032-225, OR ALS4-1032-225, OR AKS4-1032-225) |
| 50 | 4 | 4 | 1 | 1 | | | D2736-1 | GHW LUG |
| 51 | 8 | 8 | 4 | 4 | | | AN446A | BOLT |
| 52 | 16 | 16 | 8 | 8 | | | D2578 | BUSHING |
| 53 | 8 | 8 | 4 | 4 | | | MS21042L4 | NUT (OR MS21042-4) |
| 54 | | | 1 | 1 | | | D2766-3 | LUG ASSEMBLY |
| 60 | 1 | 1 | 1 | 1 | | | D2968-041 | TOW RING |
| 61 | 1 | 1 | 1 | 1 | | | AN970-4 | WASHER |
| 62 | 1 | 1 | 1 | 1 | | | MS21042L4 | NUT (OR MS21042-4) |

* DENOTES THAT PART IS INCLUDED WITH D2906-041/-043 SKIDTUBE ASSEMBLY

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Revision: B

Date: 07.08.23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

REFERENCE ONLY

5.0 PARTS LIST

| ITEM | QTY -011 | QTY -012 | QTY -013 | QTY -014 | QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|--|
| | X | | | | | | D209-669-011 | SKIDTUBE INSTALLATION, LH (AH-1W/J) |
| | | X | | | | | D209-669-012 | SKIDTUBE INSTALLATION, RH (AH-1W/J) |
| | | | X | | | | D209-669-013 | SKIDTUBE INSTALLATION, LH (AH-1P/F/S) |
| | | | | X | | | D209-669-014 | SKIDTUBE INSTALLATION, RH (AH-1P/F/S) |
| | 1 | 1 | | | X | | D209-669-041 | REPLACEMENT SKIDTUBE (AH-1W/J) |
| | | | 1 | 1 | | X | D209-669-043 | REPLACEMENT SKIDTUBE (AH-1P/F/S) |

IS:

| | | | | | | | | |
|----|----|----|---|---|--|--|-----------|-------------------|
| 50 | 4 | 4 | 1 | 1 | | | D3405-041 | LUG ASSEMBLY |
| 51 | 8 | 8 | 4 | 4 | | | AN4C47A | BOLT |
| 52 | 16 | 16 | 8 | 8 | | | D2570 | BUSHING |
| 53 | 8 | 8 | 4 | 4 | | | MS21043-4 | NUT |
| 54 | | | 1 | 1 | | | D3405-043 | LUG ASSEMBLY |
| 60 | 1 | 1 | 1 | 1 | | | D3407-041 | TOW RING ASSEMBLY |
| 61 | 1 | 1 | 1 | 1 | | | D3456-1 | WASHER |
| 62 | 1 | 1 | 1 | 1 | | | MS21043-4 | NUT |
| 63 | 2 | 2 | 2 | 2 | | | D3417-5 | WASHER |

WAS:

| | | | | | | | | |
|----|----|----|---|---|--|--|-----------|--------------------|
| 50 | 4 | 4 | 1 | 1 | | | D2736-1 | GHW LUG |
| 51 | 8 | 8 | 4 | 4 | | | AN4-46A | BOLT |
| 52 | 16 | 16 | 8 | 8 | | | D2570 | BUSHING |
| 53 | 8 | 8 | 4 | 4 | | | MS21042L4 | NUT (OR MS21042-4) |
| 54 | | | 1 | 1 | | | D2736-3 | GHW LUG |
| 60 | 1 | 1 | 1 | 1 | | | D2968-041 | TOW RING |
| 61 | 1 | 1 | 1 | 1 | | | AN970-4 | WASHER |
| 62 | 1 | 1 | 1 | 1 | | | MS21042L4 | NUT (OR MS21042-4) |

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|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9450 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE INSTALLATIONS | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries